LNP™ THERMOCOMP™ Compound RX06420

RF-1004 EM LE MR
REGION AMERICAS

DESCRIPTION

LNP THERMOCOMP RX06420 compound is based on Nylon 6/6 resin containing 20% glass fiber. Added features of this grade include: Easy Molding, Low Extractables, Mold Release.

GENERAL INFORMATION	
Features	Good Processability, Food contact, Enhanced mold release, High stiffness/Strength, No PFAS intentionally added
Fillers	Glass Fiber (Total fluorine >50ppm only from inorganic fluorine)
Polymer Types	Polyamide 66 (Nylon 66)
Processing Techniques	Injection Molding

INDUSTRY	SUB INDUSTRY
Building and Construction	Water Management
Consumer	Home Appliances
Packaging	Industrial Packaging, Food & Beverage

TYPICAL PROPERTY VALUES

Revision 20260204

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL [1]			
Flexural Stress, brk, 1.3 mm/min, 50 mm span	161	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	5990	MPa	ASTM D790
Flexural Modulus, 2 mm/min	5580	MPa	ISO 178
IMPACT [1]			
Izod Impact, unnotched, 23°C	423	J/m	ASTM D4812
Izod Impact, notched, 23°C	50	J/m	ASTM D256
THERMAL [1]			
HDT, 1.82 MPa, 3.2mm, unannealed	221	°C	ASTM D648
PHYSICAL [1]			
Density	1.29	g/cm³	ASTM D792
Mold Shrinkage, flow, 24 hrs [2]	1 – 3	%	ASTM D955
INJECTION MOLDING [3]			
Drying Temperature	80	°C	
Drying Time	4	Hrs	
Maximum Moisture Content	0.15 – 0.25	%	
Melt Temperature	280 – 305	°C	
Front - Zone 3 Temperature	295 – 305	°C	
Middle - Zone 2 Temperature	280 – 295	°C	
Rear - Zone 1 Temperature	265 – 275	°C	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Mold Temperature	95 – 110	°C	
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

(1) The information stated on Technical Datasheets should be used as indicative only for material selection purposes and not be utilized as specification or used for part or tool design.

(2) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

(3) Injection Molding parameters are only mentioned as general guidelines. These may not apply or may need adjustment in specific situations such as low shot sizes, large part molding, thin wall molding and gas-assist molding.

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